

Date: Tuesday, 04/07/2006 1:58:03 PM
 User: Linda Lacelle

Process Sheet

| | |
|---|-------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STEP LEG |
| Job Number : 27756B | |
| Estimate Number : 10353 | |
| P.O. Number : N/A | Part Number : D2278 |
| This Issue : 04/07/2006 S.O. No. : N/A | Drawing Number : D2278 REV E |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 28/06/2006 Type : SMALL /MED FAB | Drawing Revision : E |
| Previous Run : 25395B | Material : N/A |
| Written By : <u>See Comment Below</u> | Due Date : 12/07/2006 |
| Checked & Approved By : | Qty: 40 Um: Each |
| Comment : Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now 6061-T6 06-06-23 JLM | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S080 | 6061-T6 .080 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s)
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick
 (M6061T6S.080)
 Identify as D2278
 Batch: 1101178

MM 06 07 12

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|

**Comment:** FLOW WATER JET

MM 06 07 13



(40)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

MM 06 07 13

(40)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK

06 07 20

(40)

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

SAD 06:07:27

M.F. 06/07/27

(40)

Date: Tuesday, 04/07/2006 1:58:04 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 27756B

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF 06/07/27

(40)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 06/07/28

40

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD 06/07/31

40

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 06/08/01

(40)

Job Completion



C206108/01

Date: Wednesday, 6/28/2006 4:18:31 PM
 User: Kim Johnston

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STEP LEG |
| Job Number : 27756B | |
| Estimate Number : 10353 | |
| P.O. Number : | Part Number : D2278 |
| This Issue : 6/28/2006 S.O. No. : | Drawing Number : D2278 REV E |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : E |
| Previous Run : 25395B | Material : |
| Written By : | Due Date : 7/12/2006 Qty: 40 Um: Each |
| Checked & Approved By : | |
| Comment : Est Rev:A New Issue 05-11-07 JLM | |
| Est Rev:B Now 6061-T6 06-06-23 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S080 | 6061-T6 .080 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s)
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick
 (M6061T62S.080)
 Identify as D2278
 Batch: M101179

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR
 Cut blanks: (16.61" x 8.51") +.000/-0.020" (grain along 8.51") for each leg

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1 Machine as per folio D2278, use stack of 10

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



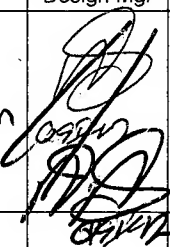

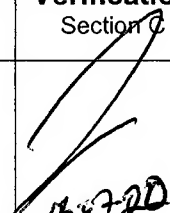
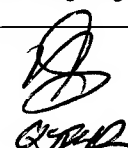
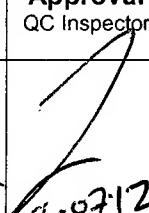
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: 27756B | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------|------|--|--|--|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| 060712 | 2.0 | 6 prices cut with wrong grain direction |  | Destroy scrap prices and cut new ones |  060712 |  060720 |  060712 |  060712 |
| | | | | | | | | |
| | | | | | | | | |

Part No: D2278 PAR # NA Fault Category: Prod / Machine ^{PARTS} NCR: Yes No DQA: Yes Date: 060810
 NOTE: Date & initial all entries QA: N/C Closed: Yes Date: 06.08.03

Date: Wednesday, 6/28/2006 4:18:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 27756B

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3-

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |


| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

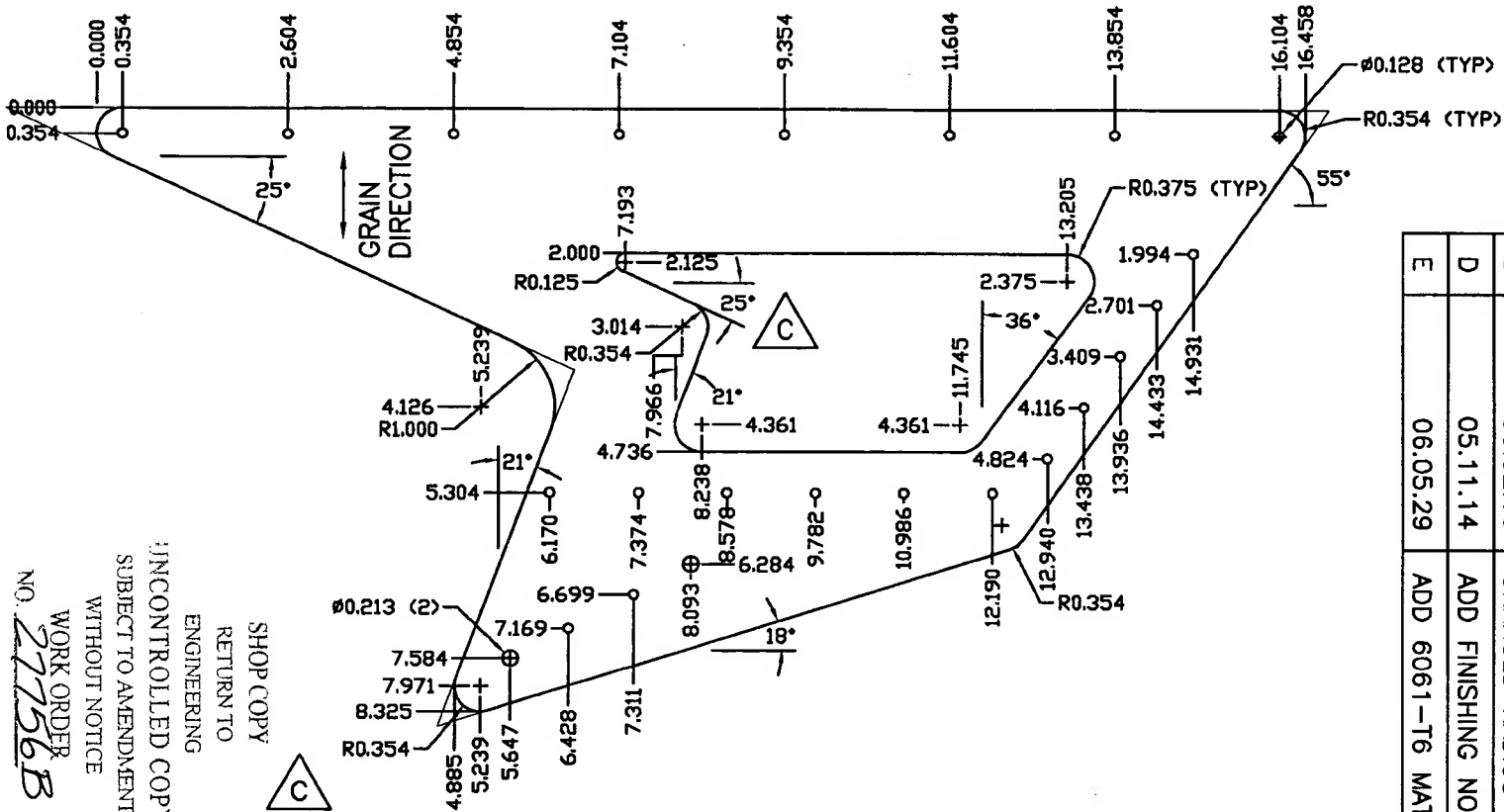
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

| | | | | |
|------------------|---|-------------------------|---|--|
| DESIGN BW | | DRAWN BY CB | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | |
| CHECKED BH | APPROVED  | DRAWING NO. D2278 | REV. E SHEET 1 OF 1 | |
| DATE 06.05.29 | | TITLE LEG | SCALE 1:2.5 | |
| C | 95.02.16 | CHANGED RADIUS TO 0.354 | | |
| D | 05.11.14 | ADD FINISHING NOTE | | |
| E | 06.05.29 | ADD 6061-T6 MATERIAL | | |



- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 ALUMINUM SHEET (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

06.06.20 *[Signature]*

06.06.20

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WITHOUT NOTICE
WORK ORDER
NO. 27756B
D2278 LEG

